

Work Order ID 155181

Monday, January 09, 2017 8:03:12 PM

155181

Page 1

** for Pull Test **

Item ID: D5350-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Beam Assembly
 Start Date: 01/09/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/12/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start ***NR1***
 QC: *[Signature]* Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5350	<i>ex Rev C</i>								
110		0.00							
110					DAS 30 9-89	<i>1</i>			JAN 11 2017
Small Fab	Memo	0.04							
Small Fab	ASSEMBLE AS PER DWG SEE NOTE 9 FOR TORQUE SPEC ON NUTS								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									

POSITIVE RECALL
EFFECTIVE *12.01.11* **AUTH** *9*
RELEASED _____ **DATE** _____

2017-1016-01
[Signature]
 JAN 12 2017

Picklist Print

Page 1

Monday, January 09, 2017 8:03:11 PM

Work Order ID: 155181

155181

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-11 *D2690-11* Lanyard Assembly		Manufactured	No				Each	0.0000		2			
								615527	**	2	DAS 30 9-89	JAN 11 2017	
D3917-3 *D3917-3* Washer		Manufactured	No				Each	69.0000	**	2	DAS 30 9-89	JAN 11 2017	
				<u>Location</u>				<u>Loc Qty</u>					
				ST058				69					
				151081				16		2			
				152988				53					
D5205-1 *D5205-1* Bracket		Manufactured	No				Each	5.0000	**	1	DAS 30 9-89	JAN 11 2017	
				<u>Location</u>				<u>Loc Qty</u>					
				ST157				5					
				139876				1		1			
				148631				4					
D5346-3 *D5346-3* Bushing		Manufactured	No				Each	0.0000	**	4			
D5350-1 *D5350-1* Fwd Beam		Manufactured	No				Each	0.0000	**	1	DAS 30 9-89	B155096	

JAN 11 2017

Picklist Print

Page 2

Monday, January 09, 2017 8:03:11 PM

Work Order ID: 155181

155181

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/12/2017

Start Qty: 1.00

Required Qty: 1.00

D5350-5

Manufactured No

Each 0.0000

1

DAS

D5350-5

Adapter

AN3-13A

Purchased No

Each 90.0000

2

DAS

AN3-13A

Bolt

**

DAS

30

9-89

JAN 11 2017

Location

Loc Qty

Loc Code

GA

16

m127070

16

ST349

74

153845

74

2

AN310-4

Purchased No

Each 103.0000

1

DAS

AN310-4

Nut

**

DAS

30

9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

40

M135704

0

M136295

40

ST331

38

M135704

3

M135999

35

1

DAS

30

9-89

AN4-20

Purchased No

Each 0.0000

1

AN4-20

Bolt

**

JAN 11 2017

M 136573

①

Picklist Print

Monday, January 09, 2017 8:03:11 PM

Work Order ID: 155181

155181

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C412

Purchased

No

Each

6.0000

2

DAS
30
9-89

JAN 11 2017

MS17984-C412

Pin, Quick Release

**

Location

Loc Qty

Loc Code

ST315

6

m130358

1

m135297

5

Each

1,699.000

2

**

DAS
30
9-89

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

162

m134360

108

m135135

54

ST303

1437

M136044

337

M136192

600

M136406

500

Each

190.0000

1

**

DAS
30
9-89

JAN 11 2017

MS24665-151

Purchased

No

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

130

m135274

30

m136444

100

Picklist Print

Page 4

Monday, January 09, 2017 8:03:11 PM

Work Order ID: 155181

155181

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Beam Assembly

Start Date: 01/09/2017

Required Date: 01/12/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0316J

Purchased

No

Each

1,116.000

4

DAS
30
9-89

JAN 11 2017

NAS1149D0316.I

**

Washer

Location

Loc Qty

Loc Code

ST264

1116

M134502

1116

4

NAS1149D0416J

Purchased

No

Each

3,949.000

2

30
9-89

NAS1149D0416.I

**

WASHER

Location

Loc Qty

Loc Code

GA

7

m131511

7

ST260a

2492

m131511

2492

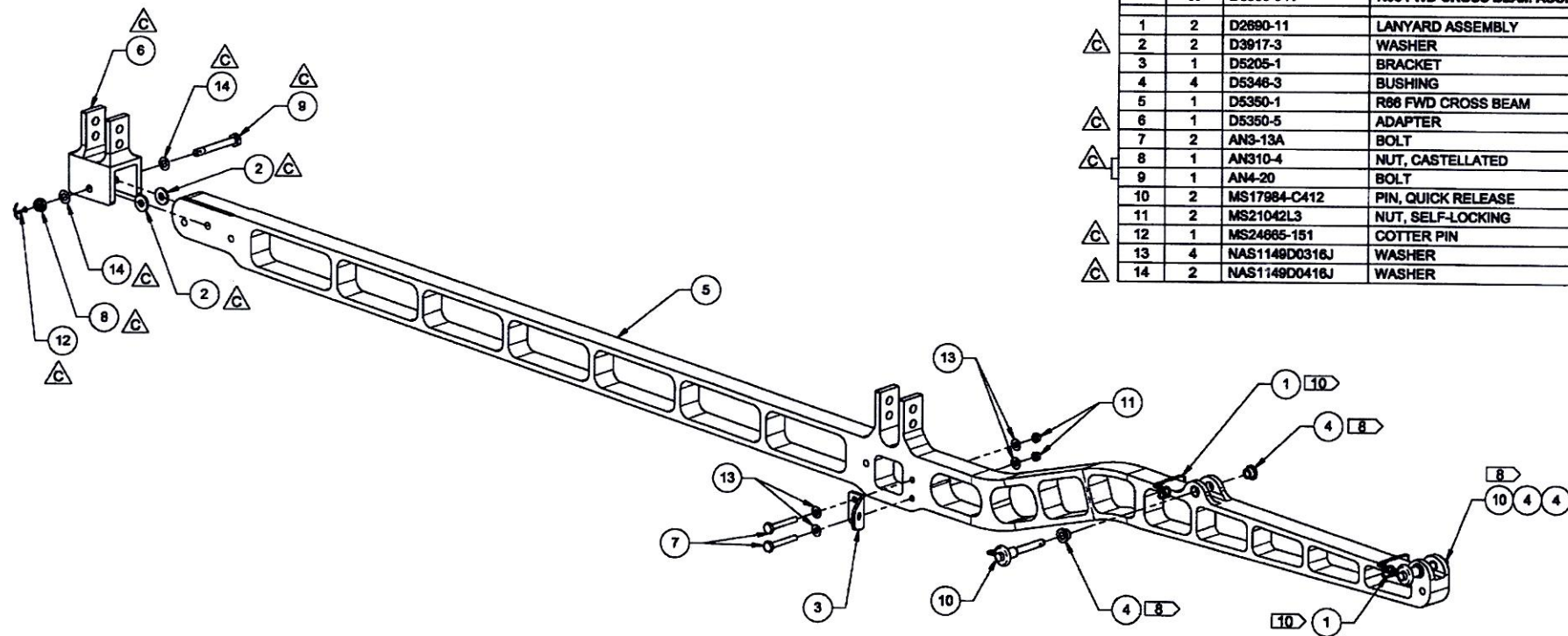
ST264

1450

m131511

1450

2



ITEM	QTY	P/N	DESCRIPTION
	X	D5350-041	R66 FWD CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	1	D5205-1	BRACKET
4	4	D5346-3	BUSHING
5	1	D5350-1	R66 FWD CROSS BEAM
6	1	D5350-5	ADAPTER
7	2	AN3-13A	BOLT
8	1	AN310-4	NUT, CASTELLATED
9	1	AN4-20	BOLT
10	2	MS17984-C412	PIN, QUICK RELEASE
11	2	MS21042L3	NUT, SELF-LOCKING
12	1	MS24865-151	COTTER PIN
13	4	NAS1149D0316J	WASHER
14	2	NAS1149D0416J	WASHER

D5350-041 R66 FWD CROSS BEAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.96 lbs
- 8) PRESS FIT D5346-3 INTO D5350-1
- 9) TORQUE MS21042L3 NUTS TO 20-25 in-lb (2.3-2.8 N-m)
- 10) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

C	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4); ADDED -5 (ZN A4-5) & NOTE 10 & 11 (ZN A5-3, A5-4); REVISE BOM% ZN (D3-1, D3-2)	RF	16.11.18
B	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	WK		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	16.11.18		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5350

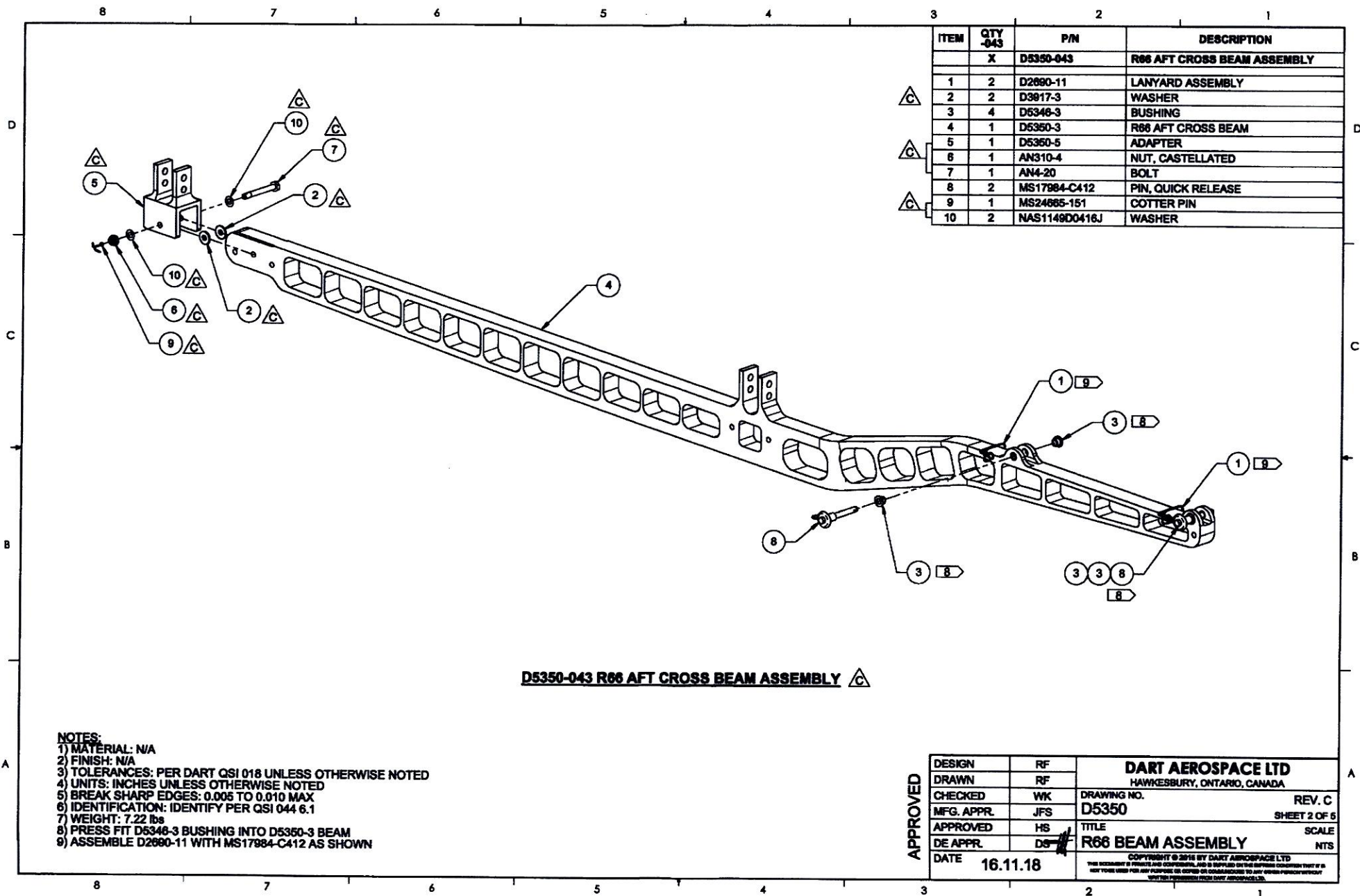
REV. C
SHEET 1 OF 5

TITLE

R66 BEAM ASSEMBLY

SCALE
NTS

COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

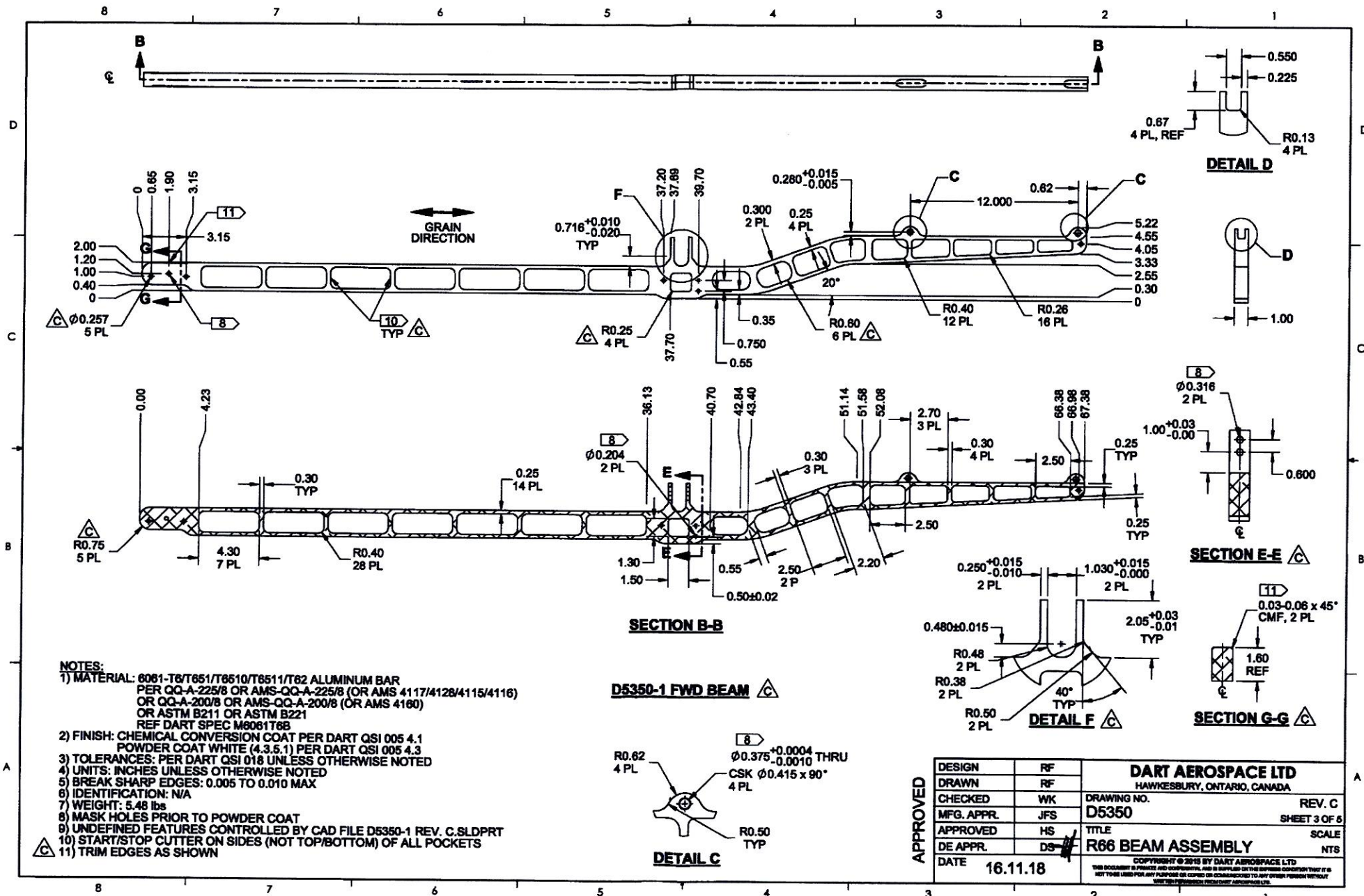


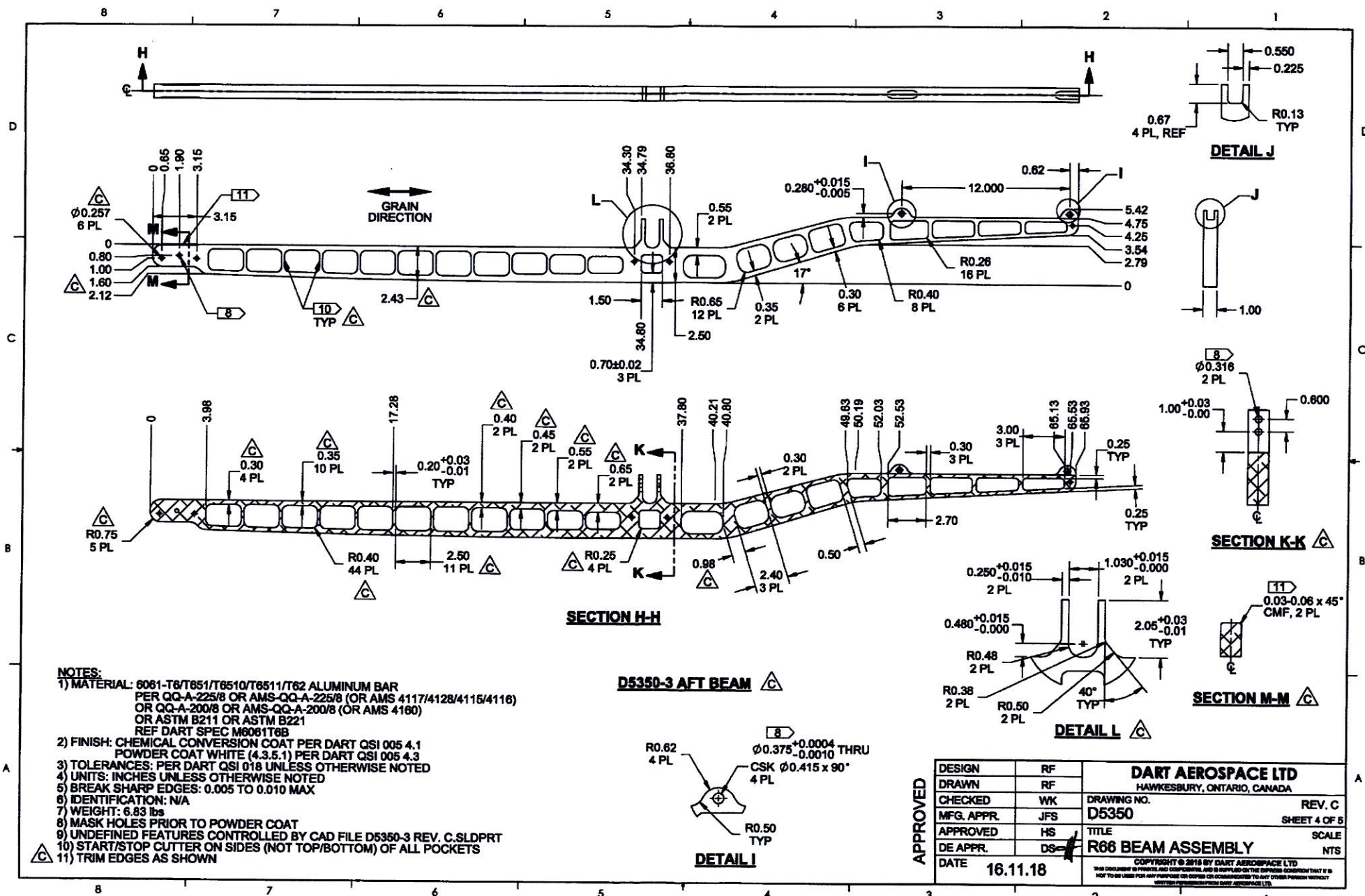
ITEM	QTY	P/N	DESCRIPTION
	X	D5350-043	R66 AFT CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	4	D5346-3	BUSHING
4	1	D5350-3	R66 AFT CROSS BEAM
5	1	D5350-5	ADAPTER
6	1	AN310-4	NUT, CASTELLATED
7	1	AN4-20	BOLT
8	2	MS17984-C412	PIN, QUICK RELEASE
9	1	MS24685-151	COTTER PIN
10	2	NAS1149D0416J	WASHER

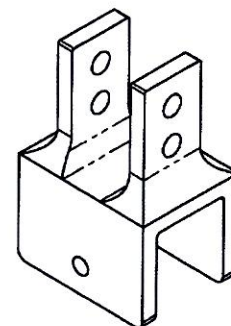
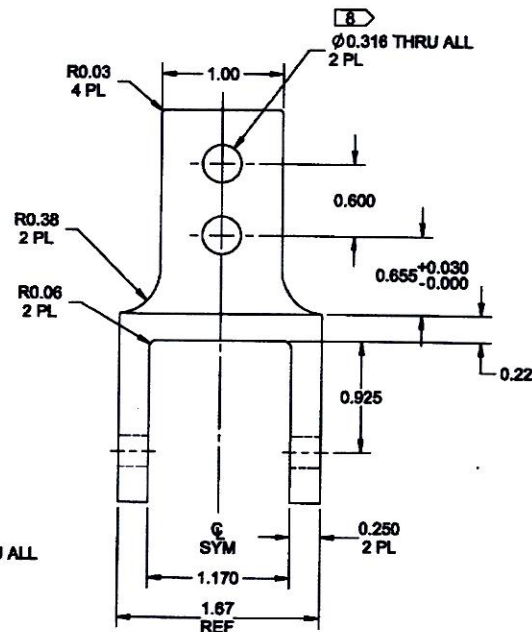
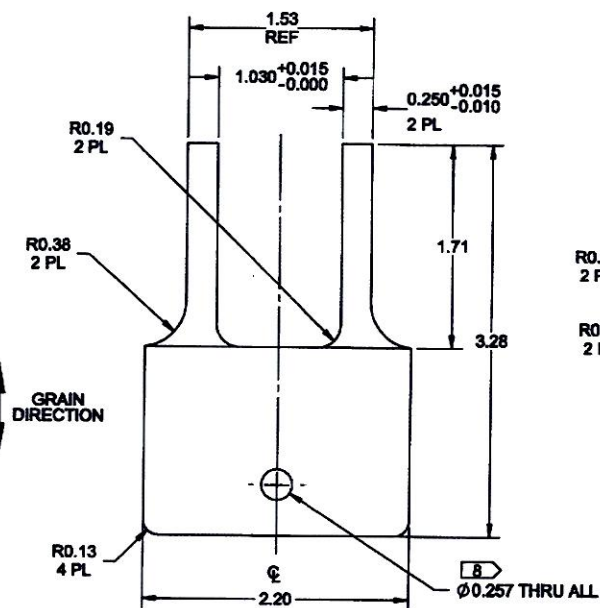
D5350-043 R66 AFT CROSS BEAM ASSEMBLY C

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 7.22 lbs
 - 8) PRESS FIT D5346-3 BUSHING INTO D5350-3 BEAM
 - 9) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	WK	DRAWING NO. D5350	REV. C
	MFG. APPR.	JFS	SHEET 2 OF 5	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
DATE 16.11.18		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED BY THE DEFENSE COORDINATOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.		







D5350-5 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T65
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5350	SHEET 5 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
DATE	16.11.18	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONDUCTED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	